

Date: Friday, 18/07/2008 10:50:38 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HEATER TUBE 6"	
<b>Job Number</b> :	40622	<b>Part Number</b> :	D2293	
<b>Estimate Number</b> :	12699	<b>Drawing Number</b> :	D2293 REV. B	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	18/07/2008	<b>Drawing Revision</b> :	B	
<b>Prsht Rev.</b> :	NC	<b>Material</b> :		
<b>First Issue</b> :	1/1	<b>Due Date</b> :	10/08/2008	<b>Qty:</b> 8 Um: Each
<b>Previous Run</b> :	31185	<b>Type</b> :	SMALL /MED FAB	
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :	<u>JUD 08.7.18</u>			
<b>Comment</b> :	Est Rev:A New Issue 07-02-02			

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T6000W250

6061-T6 RD Tube 6.00 X .250W



Comment: Qty.: 0.0875 f(s)/Unit Total: 0.6997 f(s)

6061-T6 Tube 6.00x.250W

Material: 6061-T6 (6" OD x 0.250") wall seamless tubing

(M6061T6T6.000W.250)

Batch: M103436mmf 08/07/19

2.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

TURN I.D AS PER DWG D2292

J.F. / mmf 08/07/19

(8)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. mmf 08/07/19

(8)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

10 08/07/22

(8)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST1208/07/22

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2293 PAR #: N/A Fault Category: Prod / machined parts NCR: Yes No DQA: D Date: 08/07/07  
 QA: N/C Closed: D Date: 08/07/09

NCR: <u>40622</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/01</u>	<u>#</u> <u>2.0</u>	two parts scrap. - one part 1.000" dim is 0.977" - one part wall thickness is <del>0.125</del> " 0.106" instead of 0.125" R.C. one slipped Durheim machine - operator didn't measure correctly.	<u>[Signature]</u>	Scrap and Destroy and replace Qty <u>(x2)</u> <u>R# 103430</u>	<u>[Signature]</u> <u>08/07/01</u>	<u>S</u> <u>08/07/02</u>	<u>[Signature]</u> <u>08/07/02</u>	<u>S</u> <u>08/07/01</u>
					<u>[Signature]</u> <u>08/07/01</u>	<u>S</u> <u>08/07/02</u>		<u>S</u> <u>08/07/01</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER TUBE 6"

Job Number: 40622

Part Number: D2293

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23  
MF 08-07-23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

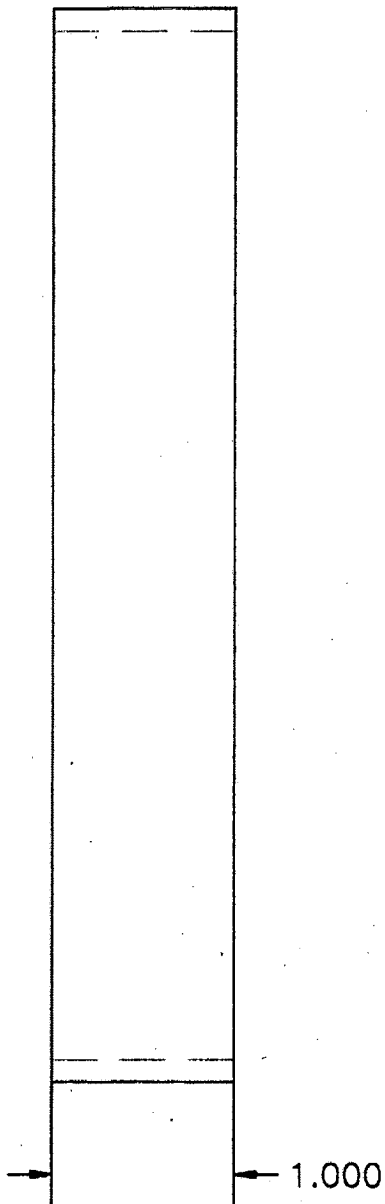
NOTE: Date & initial all entries



**DART**



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2293	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 6" HEATER TUBE	SCALE 1:1
B	96.01.15	CHANGED MATERIAL	



MATERIAL: 6061-T6 TUBE  
6" DIAM 0.125 WALL CUT 1" LONG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40622